Work Order ID Friday, February 15, 201			*97356*							Page 1
Item ID: D3933-2 Revision ID: Item Name: Aft Cabin Start Date: 2/15/20 Required Date: 2/22/20	n Wall Protector, RH	*4* *4*	*N900040100° 4* Cust Item ID: Customer:)*	Setup Sta	i VI	S1* S2*		
Reference: Approvals: Proces QC:	s Plan:	Date: 3-2- 9 Date:	_	D:	ate:		I	Run Sta Sto	[/] "	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3933	Revision Nbr									
100 Waterjet FLOW CNC Waterjet	Dwg Rev: Prog Rev:		0.00				6			JMB.2-2
*110 *11 0 * QC	QC2- Inspect parts off	machine FAI/FAIB	0.00				6		•	JMB-2-21

0.00

Memo

Quality Control

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	COI	VFORM	MANCE / UPI	DATE	0.4.61	D-4-	
						· · · · · · · · · · · · · · · · · · ·			·		QA Closed:	Date	:
Work Ord	.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	ег.					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	v O.					Use-as-is Thermoforming			Finishing	-1	re/Packaging	Other	
NCR No.			Work Order Update	1	l.	Large Fab	Composite	1 1100,3101	Supplier	1			
New No.						J		ů L	' L	_]			
Root					Descri	iption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	ļ	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling				:									
Operator				<u> </u> 			1						
Material	Ш												
Setup	Ш						İ						•
Other							ļ						
Process	Ш			·									
Supplier	Ш												İ
Training	Ш										1		
Unapproved													
							AUI	T CATE	GORY				
Landi	<u> </u>	1			_	General		l			٦	Г	7
		Bending				Bend	\vdash	Grain		 	Ovalized	-	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	U/S	BOM/Route	-	Hardwa		-	Over/Under	⊢	Temperature/Cure
 			Broken/Damaged	<u> </u>	1	on Incomplete	l lucal and	Part Incorre	<u> </u>	Weld			
					Burrs	\vdash	4	ions incomplete/	Unclear	Part Lost/M Part Moved		Wrong Stock Pulled	
	Cuffs Heat Treat			Countersink	-	Mainte		-	Part Moved				
l .		IHRAT ITRA	a t			a concersion		TIVIISIADE	1 		- 120811101160 1	WIGHP	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Friday, Februar				*973	56*				No. 1 (A)		Page 2
Item ID: Revision ID: Item Name:	D3933-2 Aft Cabin Wa	all Protector, RH		Accept	*N900	040	100) * s	Setup Star Stop	ı VI,	S1* S2*
Start Date: Required Date: Reference:	2/15/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				I VI	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:	- 	I	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo	and check	Set Up/ Run Hours 0.00 OAS 0.00 SAS 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location: PP 196841 49 SBN チャ	0.00					(4	/3/2/Se	(6)
140 *140* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					12	12/	26 dy

MF 12-26

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

TTCIT.	3 / 110								QA Closed:	Date	e:	
Work Order	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part No					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality	
NCR No	0				Use-as-is Work Order Update				Rec/Store/Packaging Othe Supplier			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
,						AULT CATE	GORY					
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped.		O/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Instruc	tion Incomplete tions Incomplete/ enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			Drill Holes Drawing Finish	Out of	Calibration Sequence						
1	Wave/Twist in Tube		- 1	IFolio	I IOutsid	e Dimensions						

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Picklist Print

Friday, February 15, 2013 3:02:45 PM

Work Order ID:

97356

Parent Item:

D3933-2

Parent Item Name:

Aft Cabin Wall Protector, RH

Start Date: 2/15/2013

Required Date: 2/22/2013

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	0.0000	7.01	2011			- ··
GE PLASTICS LEXAN SI	HEET									20046	4		JM13-2-21

124654

124654

												DQA:	Date	:			
NCR:	/es	/ No					WORK ORDER NON-C	COI	NFORI	MANCE / UPI	DATE	QA Closed:	Date	:			
							DISPOSITION				AGAINST DE	······································					
Work Orde	er:			· · · · · · · · · · · · · · · · · · ·			·	,									
	Part No. NCR No.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	_	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR No.					Work Order Update]		Large Fab	Composite	J	Supplier						
Root Desc							otion of work order update	ı	nitial	Act	tion	Sign &					
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector			
oc/Data quip/Tooling perator																	
1aterial																	
etup		:															
ther																	
rocess					-												
upplier								1									
raining																	
napproved																	
							F	AUL	T CATE	GORY							
Landi	ng (Gear					General				_	_					
		Bending					Bend		Grain			Ovalized	<u></u>	Pressure/Forced			
		Centre No	ot Concer	ntric to	o/s	_	BOM/Route	_	Hardwa		<u> </u>	Over/Under	⊢	Temperature/Cure			
	<u> </u>	Cracks					Broken/Damaged	_	┥ `	on Incomplete	L	Part Incorre	<u></u>	Weld			
	_	Crushed/	Crimped.				Burrs	 	4	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte		_	Part Moved					
	_	Heat Trea					Countersink	-	Mislabe		<u> </u>	Positioned V	- · -	Пои			
		Inspection		Tube			Cut Too Short	<u> </u>	Misrea	d	L	Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes						Offset										
	_	Torque W			n		Drawing	-	4	Calibration							
	Turning Sequence Finish					Finish	1	[Out of :	Sequence								

Outside Dimensions

Wave/Twist in Tube

Folio

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DART AEROSPACE LTD	Work Order:	97356
Description: Aft Cabin Wall Protector, RH	Part Number:	D3933-2
Inspection Dwg: D3933 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0,88"			V	JHW1
19.00	+/-0.030	19.00"	_		T	Throno 6
26.75	+/-0.030	26.75"	-		T	
27.38	+/-0.030	27.38"	-		个	
34.75	+/-0.030	34.75"	_		T	
31.50	+/-0.030	31.50	_		T	
25.79	+/-0.030	25.79"	-		ナ	, -
0.125	+/-0.010	0.1264	_		V	
23.25	+/-0.030	23.25"			Т	·
			OAS			

Measured by:	Jm	Audited by:	15	Prototype Approval:	N/A
Date:	13.2-21	Date:	13221	Date:	N/A

Rev	Date	Change	Rev	ised	<mark>ل</mark> ا	/	oved	
Α	09.06.22	New Issue	KJ	94	$\langle \rangle$			
				, (



